

Date: Thursday, 7/19/2007 2:24:39 PM
 User: Kim Johnston

Process Sheet

31

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HELI ACESS STEP LH
 Job Number : 33649
 Estimate Number : 10855
 P.O. Number :
 This Issue : 7/19/2007 S.O. No. :
 Prsht Rev. : NC Part Number : D206628021BL
 First Issue : 1 / 1 Type : LARGE FAB ASSY Drawing Number : N/A
 Previous Run : 32391 Drawing Revision : N/A
 Written By :
 Checked & Approved By : 07.07.19
 Comment : Est Rev:D as per ECN 766 JLM Material :
 Due Date : 8/3/2007 Qty: 3 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels as per PPP D206-628-021 CHG 002

DETACHED

2.0 33649A 206L /407 STEP ASSY, LH



Comment: Sub-Component SUB-COMPONENT

D2724-041 B 33649A

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0 D27317 Mounting Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D2731-7 Mounting Lug

03275 633752

5.0 D2856400 Abrasion Strip



Comment: Qty.: 1.1708 f(s)/Unit Total: 3.5123 f(s)

Pick:

Qty Part # Description Batch

2 D2856-400 6.9" Abrasion Strip

032992

07/08/03 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 7/19/2007 2:24:39 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACESS STEP LH

Job Number: 33649

Part Number: D206628021BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D3394043

LUG ASS'Y



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D3394-043 LUG ASS,Y B33757

7.0

AN412A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN4-12A Bolt M104547-

8.0

AN413A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN4-13A Bolt M104746-

9.0

AN415A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN4-15A Bolt M104072-

10.0

AN960JD416

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 36.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 AN960JD416 Washer M104215-

11.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 36.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 MS21042L4 Nut (or MS21042-4) M102552-

CP 5/10/08/03 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 7/19/2007 2:24:39 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACESS STEP LH

Job Number: 33649

Part Number: D206628021BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

Exp 07/08/14

X3/16/15

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-628-021

Location: _____

PPP Rev: _____

Exp 07/08/14 (3x)

14.0

QC21

FINAL INSPECTION W/O RELEASE



Comment: FINAL INSPECTION W/O RELEASE

07.08.15

Job Completion



07.08.15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 7/19/2007 2:24:39 PM
 User: Kim Johnston

Process Sheet

31

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HELI ACCESS STEP LH
 Job Number : 33649
 Estimate Number : 10855
 P.O. Number :
 This Issue : 7/19/2007 S.O. No. :
 Prsht Rev. : NC Drawing Number : N/A
 First Issue : / / Type : LARGE FAB ASSY Project Number : N/A
 Previous Run : 32391 Drawing Revision : N/A
 Material :
 Due Date : 8/3/2007 Qty: 3 Um: Each
 Written By :
 Checked & Approved By : 07.07.19
 Comment : Est Rev:D as per ECN 766 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels as per PPP D206-628-021 CHG 002

07.07.24

2.0 33649A 206L /407 STEP ASSY, LH



Comment: Sub-Component SUB-COMPONENT

D2724-041 B _____

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0 D27317 Mounting Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D2731-7 Mounting Lug _____

REFERENCE ONLY

5.0 D2856400 Abrasion Strip



Comment: Qty.: 1.1708 f(s)/Unit Total : 3.5123 f(s)

Pick :

Qty Part # Description Batch

2 D2856-400 6.9" Abrasion Strip _____

628021 - Blue

Dart Aerospace Ltd.

31

Date: Thursday, 7/19/2007 2:24:44 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206L /407 STEP ASSY, LH
 Job Number : 33649A
 Estimate Number : 11702
 P.O. Number :
 This Issue : 7/19/2007 S.O. No. :
 Prsht Rev. : NC Part Number : D2724041
 First Issue : / / Type : LARGE FAB ASSY Drawing Number : D2724 REV C
 Previous Run : 32391A Drawing Revision : C
 Material :
 Due Date : 8/3/2007 Qty: 3 Um: Each
 Written By :
 Checked & Approved By : 07.07.19
 Comment : Est Rev:E As Per Ecn 766 06-01-06 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2622120C Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)
 Qty Part # Description Batch:
 1 D2622-120C Extrusion 332858

Check Material for any Dents or Defects

a.m 07.07.23

3

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

✓ Cut D2724-1 using D2622 extrusion as per Dwg D2724
 Deburr and bevel ends for welding

a.m 07.07.23

3

3.0 D2734 206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)
 206 Step Endplate
 Pick:

Qty Part Number Description Batch
 2 D2734 End Cap 330883

07.07.24 3

4.0 D34581 PLATE



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)
 Pick:
 Qty Part Number Description Batch
 2 D3458-1 Plate 332480

07.07.24 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 7/19/2007 2:24:44 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, LH

Job Number: 33649A

Part Number: D2724041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D34583

PLATE



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3458-3

Plate

332481

PE 07.07.24 3

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld end cap and lugs as per Dwg D2724 using Jig DT8884 followed by Jig

DT (One End Only)

A/R AL ROD Batch: M104721
M103794

Grind end cap welds flush

PE 07.07.24 3

PE 07.07.24 3

3

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PE 07.07.25 (3)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PE 07.07.25 (3) 32H

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

PE 07.07.25 3

3

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PE 07.07.25 3

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Inspect for foreign object per QSI 024

PE 07.07.25 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 7/19/2007 2:24:44 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, LH

Job Number: 33649A

Part Number: D2724041

Job Number:



Seq. #:

Machine Or Operation:

Description :

Weld Remaining end cap as per Dwg D2724 using Jig DT followed by Jig
DT
A/R AL ROD Batch: m103794

PE 07-07-25 3
PE 07-07-25 3
3

Grind per dwg D2724

Q.M. 07.07.26

12.0

DO NOT USE

WELD INSPECTION

B
3



QC9 -> PD 07-07-26 ③
QCS 07/07/26 (43H)



Comment: WELD INSPECTION

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Alodine

U

07-07-27

③

14.0

PG

PURCHASING



Comment: ISSUE P.O. 4273
ATELIER DEBOSSSELAGE
SPRAY PAINT DELFLEET BLUE
CLEAR DELFLEET

U

07-07-27

3

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
RECEIVE AND INSPECT FOR TRANSIT DAMAGE

07/8/2 ③

16.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

07/08/09 (43H)

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



m104942



Comment: Wing Walk as per Dwg D2724 and QSI 00 5 4.4

07/08/13 ③

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/08/14 (43H)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 7/19/2007 2:24:45 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, LH

Job Number: 33649A

Part Number: D2724041

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

7/19/07 33649/

7/8/14

EP. 308 50

20.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.08.15

Job Completion



07.08.15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

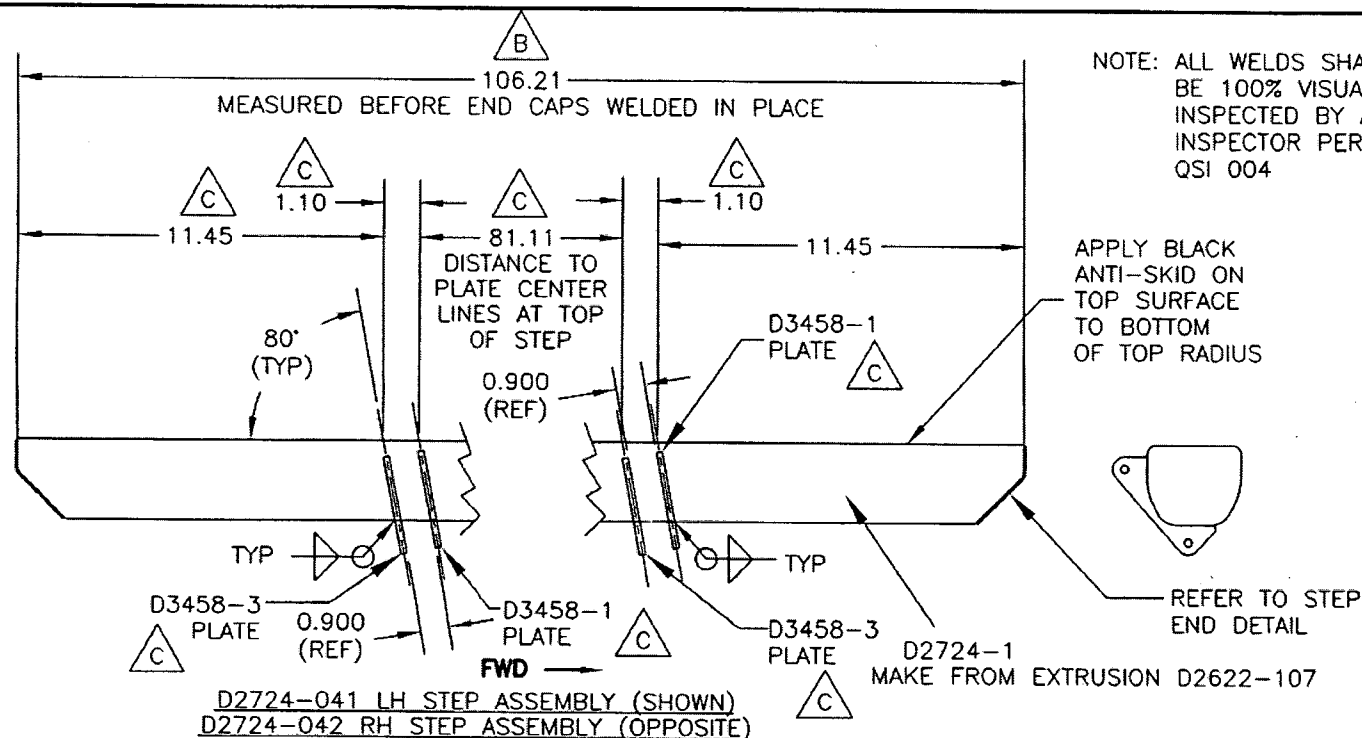
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**RELEASED**

05.11.14

NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004

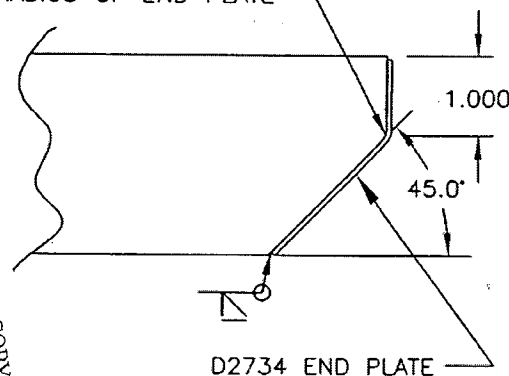
**D2721-041/-042 STEP ASSEMBLY PARTS LIST**

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE

Copyright © 2005 by DART Aerospace USA, Inc.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART Aerospace USA, Inc.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
NO 33649A

DESIGN	DRAWN BY	DART Aerospace USA, Inc.
KE	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
05.09.19	05.09.19	D2724
DATE	TITLE	206L/407 STEP ASSEMBLY
A	97.12.04	NEW ISSUE
B	98.10.19	UPDATED WELD DETAIL REVISED TOLERANCES
C	05.09.19	RE-DESIGN, ADD D3458-1/-3
SCALE	NTS	SHEET 1 OF 1

Date: Friday, 07/09/2007 1:11:06 PM
 User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D206-628
Job Number	: 34468		
Estimate Number	: 10804		
P.O. Number	: N/A	Part Number	: Z_CUSTOM
This Issue	: 07/09/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: ECN 1029
First Issue	: N/A	Project Number	: N/A
Previous Run	: 00015	Drawing Revision	: N/A
	Type : LARGE FAB ASSY	Material	: N/A
Written By	:	Due Date	: 14/09/2007
Checked & Approved By	:	Qty:	1 Um: Each
Comment	:		

Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description :

1.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

PULL FROM STK - ADD NEW PAPERWORK PER ECN 1029

EASA STC: EASA.IM.R.S.01339:

D206-628-011

33411 (3X) 33038 (4X) 32979 (1X)

D206-628-012

32980 (1X) 33892 (1X)

D206-628-013

D206-628-014

18533 (1X) 18943 (1X)

D206-628-021

31976 (3X) 33756 (3X) 29739 (1X)

D206-628-021BL

33649 (2X)

D206-628-022

33757 - 31977 (3X)

D206-628-023

33921 (1X)

D206-628-024

33922 (1X)

D206-628-031

31010 (4X)

D206-628-032

29738 (1X) 31011 (4X)

D206-628-033

30806 (2X) 31241 (2X)

D206-628-034

30807 (2X)

7/8/11 SP